

Work Order ID 55061

January 5, 2010 2:37:32 PM



Page 1

Item ID: D2144

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-1-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2144	Rev D
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100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2144 ☐ Dwg Rev: D Prog Rev: D 2-
Deburr if necessary

HB 10-1-8

(16)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-1-8

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

⇒ 81060000

(715)

P107

W/O: 55061

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/8	# 20	Took Qty of Part for QC inspection template	E	10/1/8	x1	W	S 10/1/8

Part No: D2144 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

W/A

Small Fab

Deburr if necessary

140



Brake NC

NC BRAKE

0.00

Memo

0.00

SS 10/01/20

CY

x1

PTO

Brake NC

Form as per Dwg D2144Rev:

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=> Subulba

x100

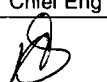
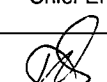
x1

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/20	14 th	1 piece was out of tolerance Set up piece R.C. process	 QEPN	Scrap no replace Keep for reference only	So 10/1/20		 QEPN	

NOTE: Date & initial all entries

Work Order ID 55061

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Start Date: 05/01/2010 Start Qty: 12.00



Cust Item #:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- Weld corner as per Dwg D2144 & QSI 004 2- Grind flush

PD 10.01.21

(14)

170



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

(14) 10/04/22

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=> 5.10/01/22

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 55061

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Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:30AM

OVEN TEMPERATURE:

9:00AM FINISH TIME

400°F

→ W 10-01-27

(X4)

φ

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

→ m-l 10/01/27

(14K)

210

Identify as per dwg & Stock Location:

195

0.00



Packaging

Memo

0.00

Packaging

10-1-27 14K

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/28
mf
10-1-28

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

January 5, 2010 2:37:37 PM

Work Order ID: 55061



Parent Item: D2144



Parent Item Name: Hinge Bracket

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304S16GA

Purchased

No

120

sf

370.2779

1.1340



304/316 Sheet .063



1810-1-8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

370.2778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

307.1895

112290

112290

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 55061
Description: HINGE BRACKET		Part Number: D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .171	+ .005 - .001	.173	✗			
Ø .257	+ .006 - .001	.257	✗			
Ø .320	+ .006 - .001	.321	✗			
1.958	+/- .010	1.963	✗			
2.312	+/- .010	2.313	✗			
1.470	+/- .010	1.472	✗			
3.465	+/- .010	3.460	✗			
4.126	+/- .010	4.133	✗			
3.294	+/- .010	3.300	✗			
2.844	+/- .010	2.846	✗			
2.312	+/- .010	2.314	✗			
1.660	+/- .010	1.663	✗			
1.000	+/- .010	.999	✗			
.625	+/- .010	.626	✗			
.340	+/- .010	.341	✗			
3.381	+/- .010	3.386	✗			
3.022	+/- .010	3.031	✗			
2.468	+/- .010	2.469	✗			
1.913	+/- .010	1.913	✗			
1.555	+/- .010	1.554	✗			
.354	+/- .010	.355	✗			
.063	+/- .010	.060	✗			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-1-8	Date: 10/1/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

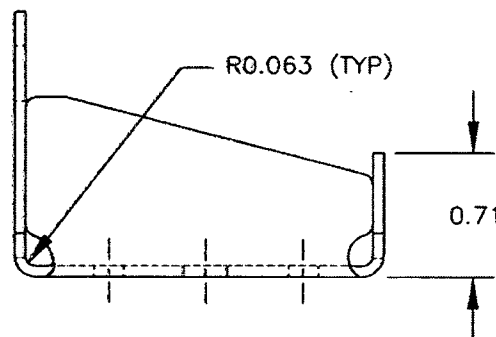
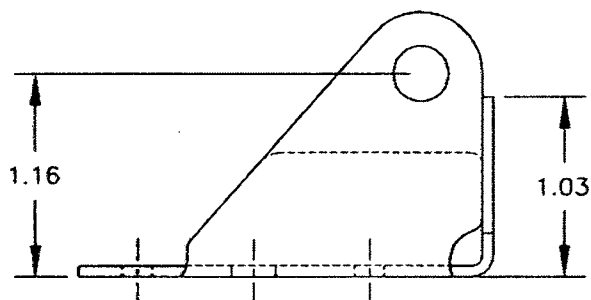
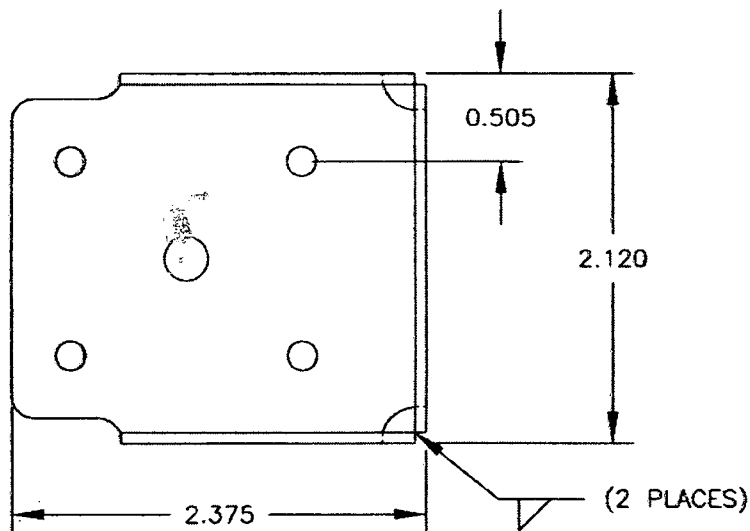


RELEASED
98.10.15 KE

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BU		KE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	WJA	APPROVED	KE	DRAWING NO.	REV. D
DATE	98.10.08	TITLE	HINGE BRACKET	D2144	SHEET 1 OF 2
			SCALE	1:1	
A	95.03.17	NEW ISSUE			
C	96.06.05	FLAT PATTERN LAYOUT ADDED			
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55061

BY 10-1-05



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

W/O:		WORK ORDER CHANGES					
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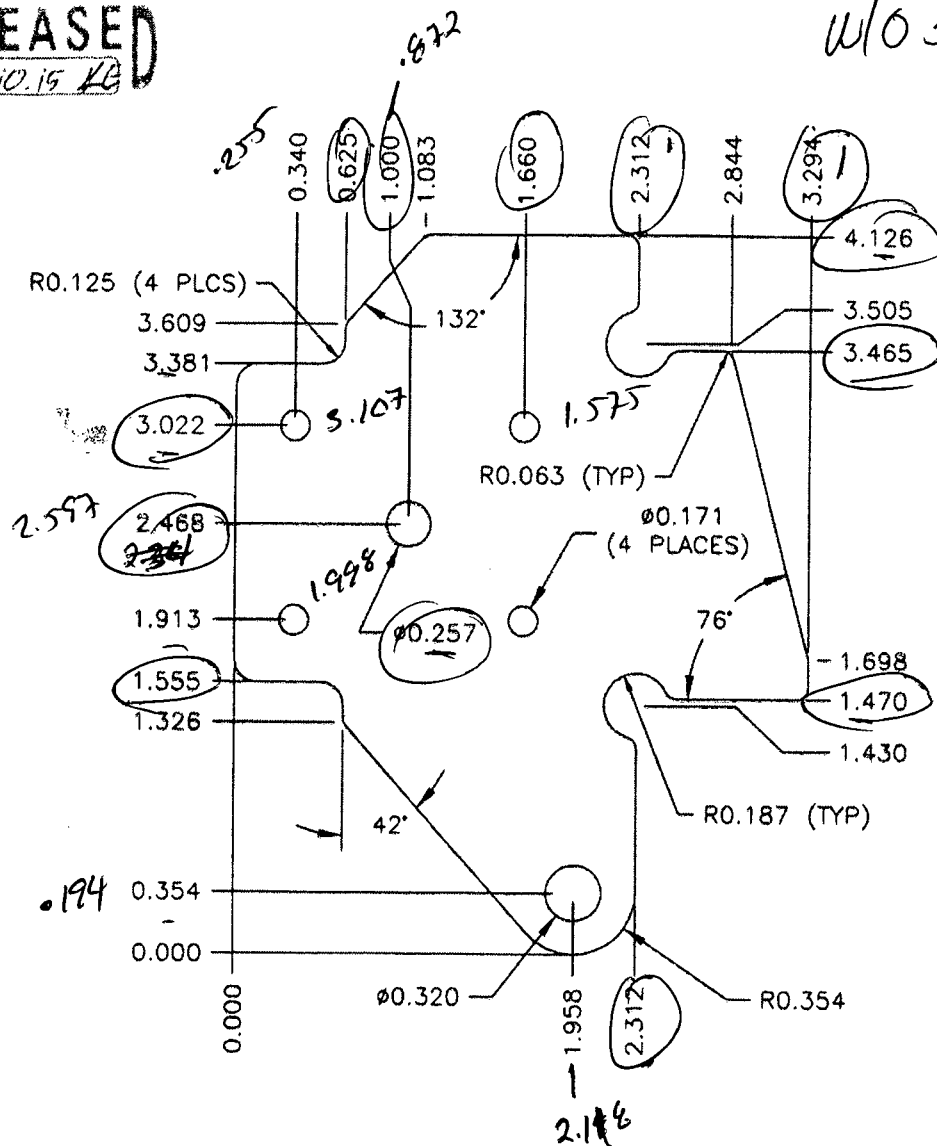
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2144	REV. 0 SHEET 2 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1

RELEASED
98.10.15 KE

W/O 55061



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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